

Date: Thursday, 14/08/2008 9:26:00 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	BEARPAW KIT (19"X24")
<b>Job Number</b> :	41228		
<b>Estimate Number</b> :	10323		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206559013
<b>This Issue</b> :	14/08/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2432 REV F3
<b>First Issue</b> :	14/08/2008	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	40581	<b>Drawing Revision</b> :	F3
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	29/08/2008
<b>Written By</b> :		<b>Qty:</b>	4
		<b>Um:</b>	Each
<b>Checked &amp; Approved By</b> :	<u>JLD 08.8.14</u>		
<b>Comment</b> :	Est Rev:J 04.02.17 Blank size changed KJ/JLM Est Rev:K 07-01-02 Was K10008 JLM Est Rev:L 08-01-09 Added Step 2 JLM Verified By:EC Est Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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JLD 08.8.26**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-013 CHG005

Sosko/w

2.0	MFG ENGINEERING	MFG ENGINEERING
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**Comment:** MFG ENGINEERING

Program Batch Number

08.09.19

3.0	MUHMWB10	UHMW 1" Black
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**Comment:** Qty.: 6.9878 sf(s)/Unit Total : 27.9510 sf(s)

blank: 19.500" x 24.00" x 1.00" thick (+0.030/-0.000) per DSK086-5

Material: Black UHMW 1"

(MUHMWB10)

Batch: M109497M.A 08/10/07

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2432 Identify as D2432F

3-Deburr

RP 08/10/09  
M.A 08/10/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*26 08/10/09 G.A 08/10/08*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*88 08/10/09 (8)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

8.0

D2182B

Rubber Cushion



Comment: Qty.: 2.6000 f(s)/Unit Total : 10.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion

*39986*

*AS 08/10/10 (x4)*

9.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block

2 D2432F(ref only) Bearpaw

*B41422x46  
B39238x2*

*Batch not in comp (the last 2)*

*AS 08/10/10 (x4)*

10.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2438 Clamp

*39440*

*AS 08/10/10 (x4)*

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Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529

Washer

41431

JS 08/10/10 (K4)

12.0

D2732

Rubber Extrusion



Comment: Qty.: 2.6000 f(s)/Unit Total : 10.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050

Rubber Cushion

38509

JS 08/10/10 (K4)

13.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A

Bolt

M108868

JS 08/10/10 (K4)

14.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A

Bolt

M107321

JS 08/10/10 (K4)

15.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416

Washer

M108827

JS 08/10/10 (K4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206559013

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M108145

SS 08/10/10 (X4)

17.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/10/10 (X4)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-013

Location:

Rev A

SS 08/10/10 (X4)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/14

Job Completion



MF 08-10-10

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 41228
<b>Description:</b> Bearpaw		<b>Part Number:</b> D2432
<b>Inspection Dwg:</b> D2432	<b>Rev:</b> F3	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.056 x 45°	✓		
B	5.500	+/-0.030	5.503	✓		
C	0.200	+/-0.030	0.195	✓		
D	0.25 x 45°	+/-0.030	0.253 x 45°	✓		
E	R0.250	+/-0.030	R0.250	✓		
F	0.250	+/-0.010	0.253	✓		
G	0.625	+/-0.030	0.623	✓		
H	0.375	+/-0.010	0.383	✓		
I	0.950	+0.030/0.010	0.956	✓		
J	19.000	+/-0.030	19.000	✓		
K	3.14	+/-0.030	3.128	✓		
L	3.28	+/-0.030	3.300	✓		
M	Ø0.260	+0.005/-0.000	Ø0.260	✓		
N	Ø0.93	+/-0.030	Ø0.938	✓		
O	0.30	+0.030/-0.000	0.315	✓		
P	23.750	+/-0.030	23.750	✓		
Q	7.375	+/-0.030	7.360	✓		
R	4.250	+/-0.010	4.252	✓		
S	2.000	+/-0.030	2.000	✓		
T	9.000	+/-0.010	9.000	✓		
U	9.000	+/-0.010	9.000	✓		
V	0.375	+/-0.010	0.379	✓		

<b>Measured by:</b> H.A.
<b>Date:</b> 08/10/09

<b>Audited by:</b> [Signature]
<b>Date:</b> 08/10/09

<b>Prototype Approval:</b> N/A
<b>Date:</b>

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF [Signature]	[Signature]

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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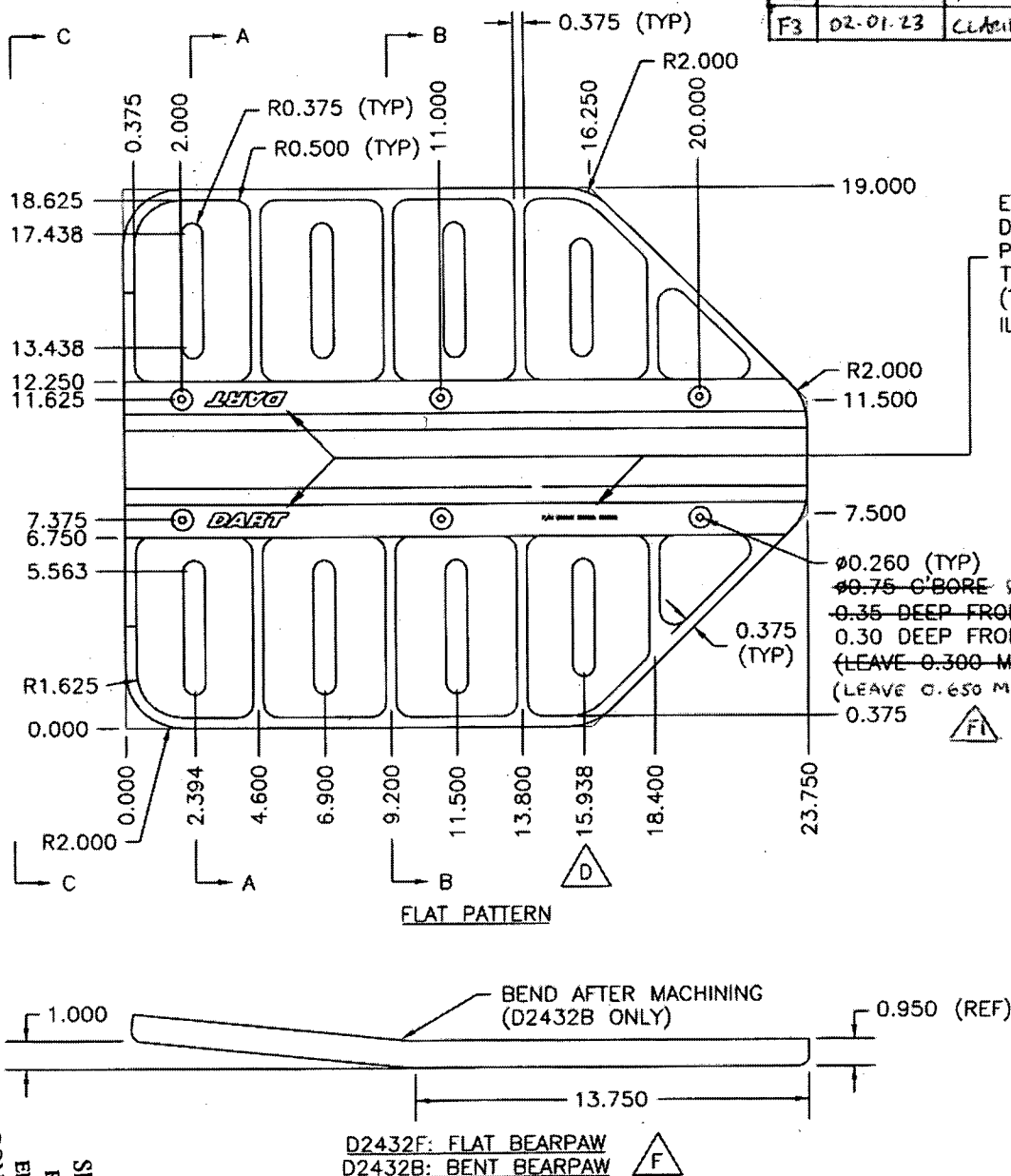
RELEASED  
49.06.17 KE

F1	99.03.03	ADD DEO 9143
F2	01.03.28	Ø0.93 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE DIMS RF

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED MM	APPROVED VA	DRAWING NO. D2432	SHEET 1 OF 2
DATE 98.05.12	TITLE BEARPAW	SCALE 1:5	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

EFFECTIVE	DEOS
9143	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

Copyright 1995 by DART AEROSPACE LTD

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71228

**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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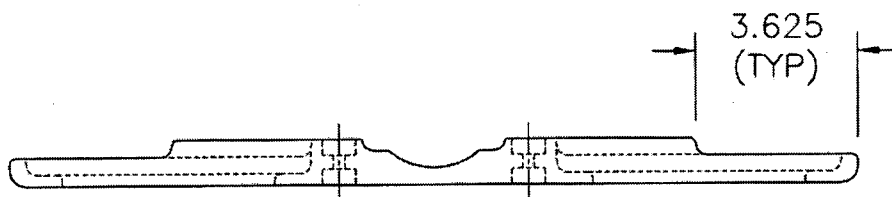
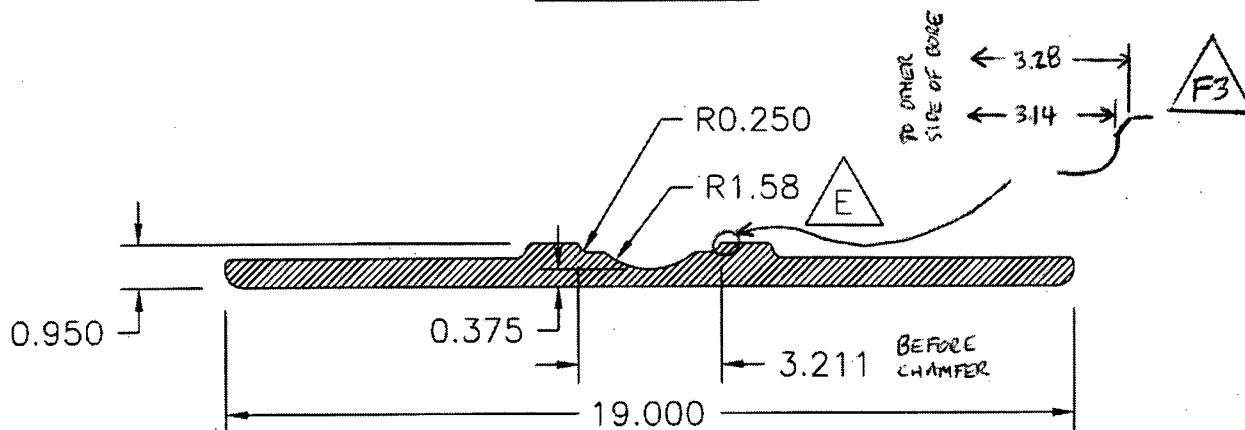
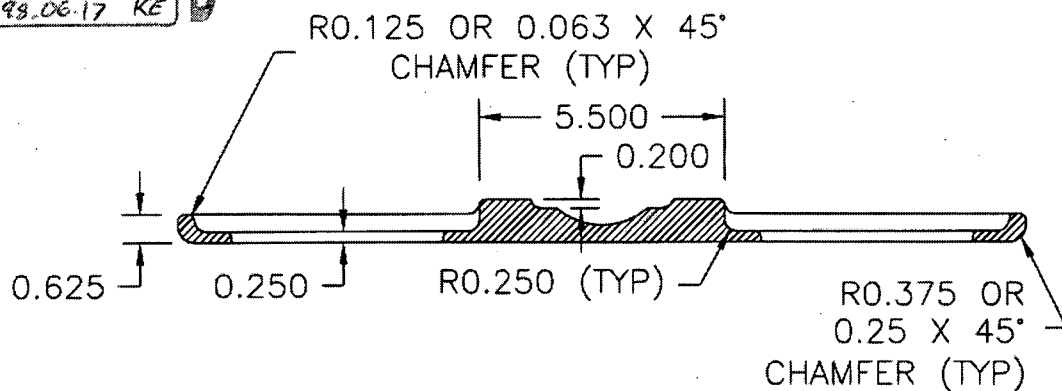
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**NOTE:** Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED JS	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

RELEASED  
98.06.17 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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